

Date: Thursday, 01/05/2008 9:45:57 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b>	: 38923		
<b>Estimate Number</b>	: 10534		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2574
<b>This Issue</b>	: 01/05/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2574 REV E
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38658	<b>Drawing Revision</b>	: E
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 10/05/2008
<b>Checked &amp; Approved By</b>	: <u>JLD 08.5.01</u>	<b>Qty:</b>	8 Um: Each
<b>Comment</b>	: Est Rev: I As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101005	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B34874

DIP 08/05/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. 2.5 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

08/05/20 DIP 2.5 08/05/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

DIP 08/05/20 2.5 08/05/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/05/20 2.5 08/05/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 01/05/2008 9:45:57 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 38923

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/05/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Bl 08-05-26

(8)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50  
220 OF  
12:20

M-L 08/05/26

(8X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-05-26

(V)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/05/27 (8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



mf 08-05-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38923
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	0.443	0.443	0.443		
B	1.745	1.755		1.749	1.749	1.750	1.750		
C	3.495	3.505		3.501	3.499	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.749		
E	7.990	8.010		7.995	7.995	7.995	7.995		
F	0.490	0.510		.502	0.495	0.502	0.494		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.496	.500	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.570	.570	.570		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.365	1.375		1.369	1.369	1.368	1.368		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		.123	.123	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.258	.258	.256	.258		
S	0.115	0.135		.130	.119	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.231	3.231		
V	0.230	0.250		.235	.230	.238	.240		
W	0.115	0.135		.135	0.130	0.129	0.129		
X	0.307	0.312		0.308	0.311	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		.367	0.358	0.366	0.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	0.627	0.625	0.625		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.513	1.520	1.512	1.508		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.253	.240	.250	.250		
AI	2.000	2.020		2.002	2.010	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: 85	Audited by: 81
Date: 08/05/17	Date: 08/05/20

Measured by: 85	Audited by: 81
Date: 08/05/17	Date: 08/05/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38923
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		7.996	7.996	7.996	7.998		
F	0.490	0.510		0.4905	0.490	0.495	0.498		
G	0.257	0.262		0.253	0.258	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.378	0.378		
I	0.490	0.510		0.497	0.496	0.494	0.496		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.565	0.565	0.562		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.372		
N	2.495	2.505		2.501	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.124	4.124		
P	0.115	0.135		0.121	0.121	0.123	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.250	0.247	0.248		
S	0.115	0.135		0.126	0.127	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.228		
V	0.230	0.250		0.230	0.233	0.233	0.232		
W	0.115	0.135		0.130	0.130	0.130	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.242	0.240		
AE	1.500	1.520		1.509	1.509	1.510	1.5105		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.241	0.246	0.244	0.2425		
AI	2.000	2.020		2.0015	2.003	2.0025	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

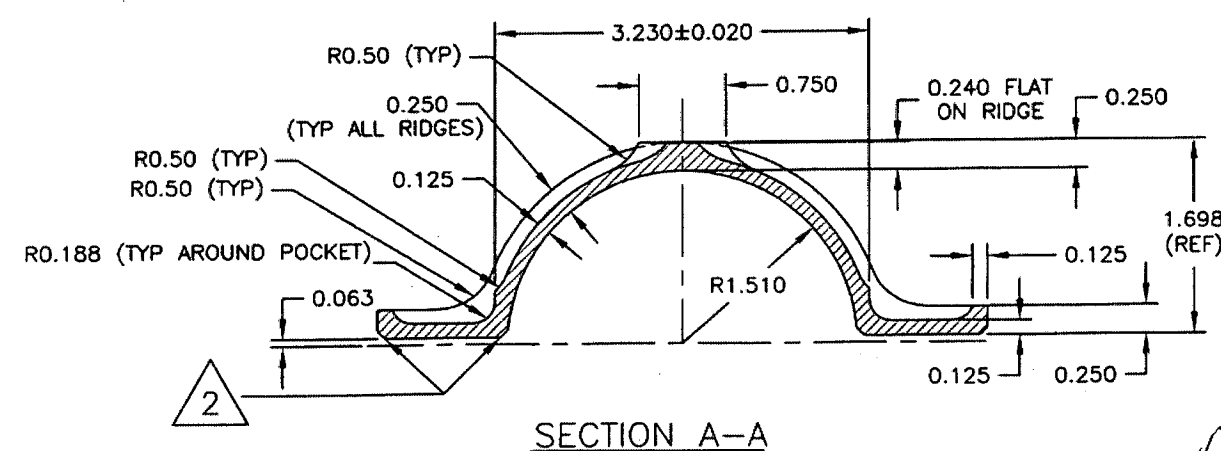
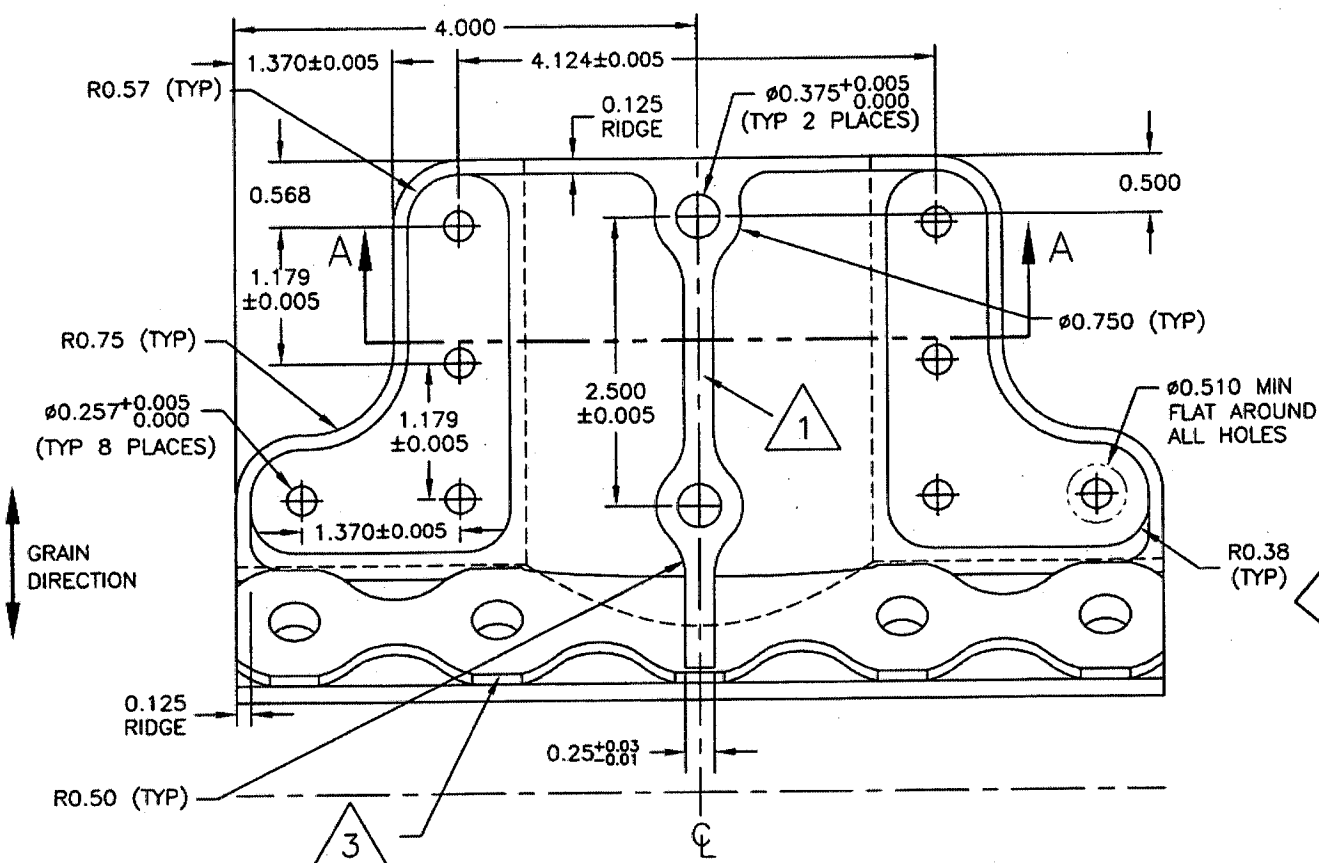
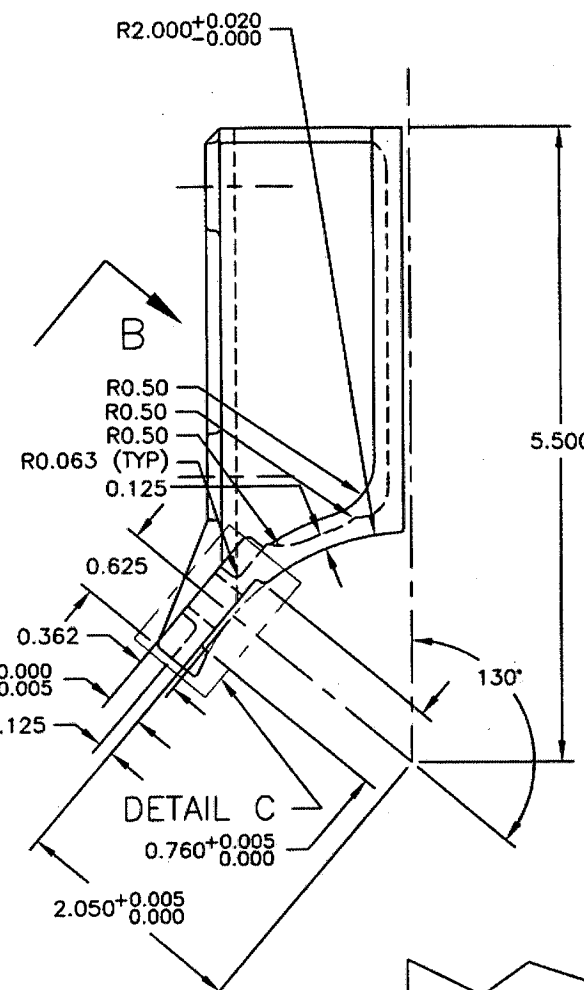
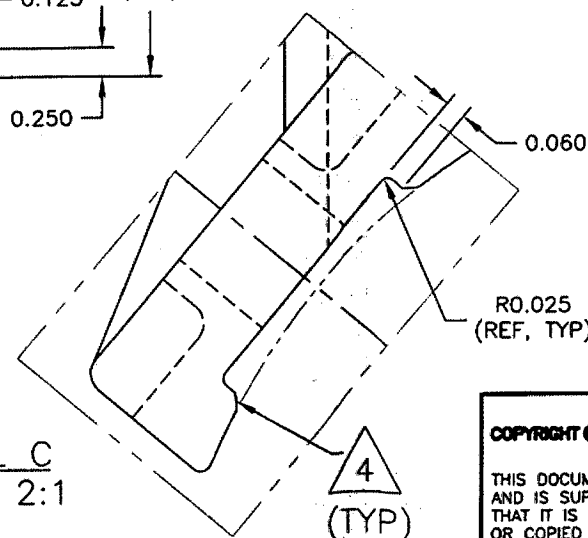
Measured by: *SA*  
Date: 08/05/18 / 08/05/21

Audited by: *SA*  
Date: 08/05/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

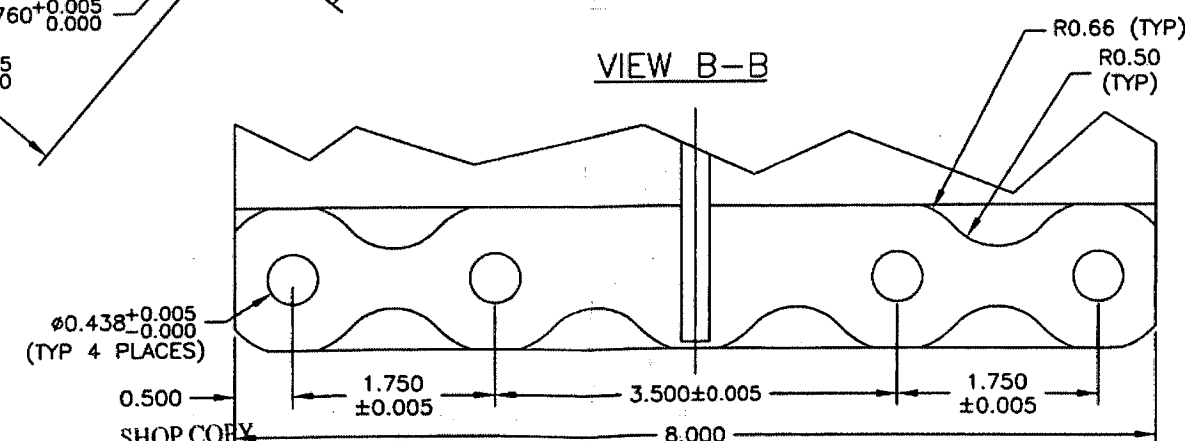
05.12.06

DETAIL C  
SCALE 2:1

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
3 CHAMFER 0.063 x 45° ALL AROUND  
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38923

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE

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DART

DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADADRAWING NO.  
D2574REV. E  
SHEET 1 OF 1SCALE  
2:3

